

Date: Wednesday, 27/08/2008 3:30:43 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services				Drawing Name	: BRACKET ASSEMBLY	
Job Number	: 41650				Part Number	: D3303043	
Estimate Number	: 10420				Drawing Number	: D3303 REV. B	
P.O. Number	:				Project Number	: N/A	
This Issue	: 27/08/2008		S.O. No.	:	Drawing Revision	: B	
Prsh Rev.	: NC				Material	:	
First Issue	: / /		Type	: SMALL /MED FAB	Due Date	: 03/09/2008	
Previous Run	: 41199				Qty:	22	Um: Each
Written By	:						
Checked & Approved By	<u>JUL 08/8/27</u>						
Comment	: Est: A 04.09.07 New Issue KJ/JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33031	Plate	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s) PLATE Pick: Qty Part Number Description Batch 1 D3303-1 Plate <u>B41219</u>	
2.0	D33033	Bracket	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 22.0000 Each(s) BRACKET Pick: Qty Part Number Description Batch 1 D3303-3 Bracket <u>B41220</u>	
3.0	MS20426AD33	Rivet	
		Comment: Qty.: 8.0000 Each(s)/Unit Total : 176.0000 Each(s) RIVET Pick: Qty Part Number Description Batch 8 MS20426AD3-3 Rivet <u>M1563</u>	
4.0	MS20470AD44	Rivet, Universal Head	
		Comment: Qty.: 16.0000 Each(s)/Unit Total : 352.0000 Each(s) Rivet, Universal Head Pick: Qty Part Number Description Batch	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action      Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, -27/08/2008 3:30:43 PM  
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Customer: CU-DAR001 Dart Helicopters Services	Drawing Name: BRACKET ASSEMBLY
Job Number: 41650	Part Number: D3303043
Job Number:	
Seq. #: Machine Or Operation:	Description :
16 MS20470AD4-4 Rivet	 M107823
5.0 MS21075L3	Nutplate  M108940
Comment: Qty.: 4.0000 Each(s)/Unit Total : 88.0000 Each(s) Nutplate Pick: Qty Part Number Description Batch 4 MS21075L3 Nut Plate	 EB M109031 (2x) 45 108751 41  108751
6.0 SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1  280828
Comment: SMALL & MEDIUM FAB RESOURCE 1 1- Assemble as per Dwg D3303 2- Identify as D3303-043	 280828 (24) created
7.0 QC5	INSPECT WORK TO CURRENT STEP  280828 X 24
Comment: INSPECT WORK TO CURRENT STEP	 280828 X 24
8.0 POWDER COATING	POWDER COATING  M106442
Comment: POWDER COATING Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 ****MASK THREADS PRIOR TO PAINT**** START TIME: OVEN TEMPERATURE: FINISH TIME:  08/08/29	 M106442
9.0 QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  08/08/29
Comment: INSPECT POWDER COAT	 08/08/29
10.0 PACKAGING 1	PACKAGING RESOURCE #1  188
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	 188 - 08/08/29 (24)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 27/08/2008 3:30:43 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 41650

Part Number: D3303043

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/02 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-08-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

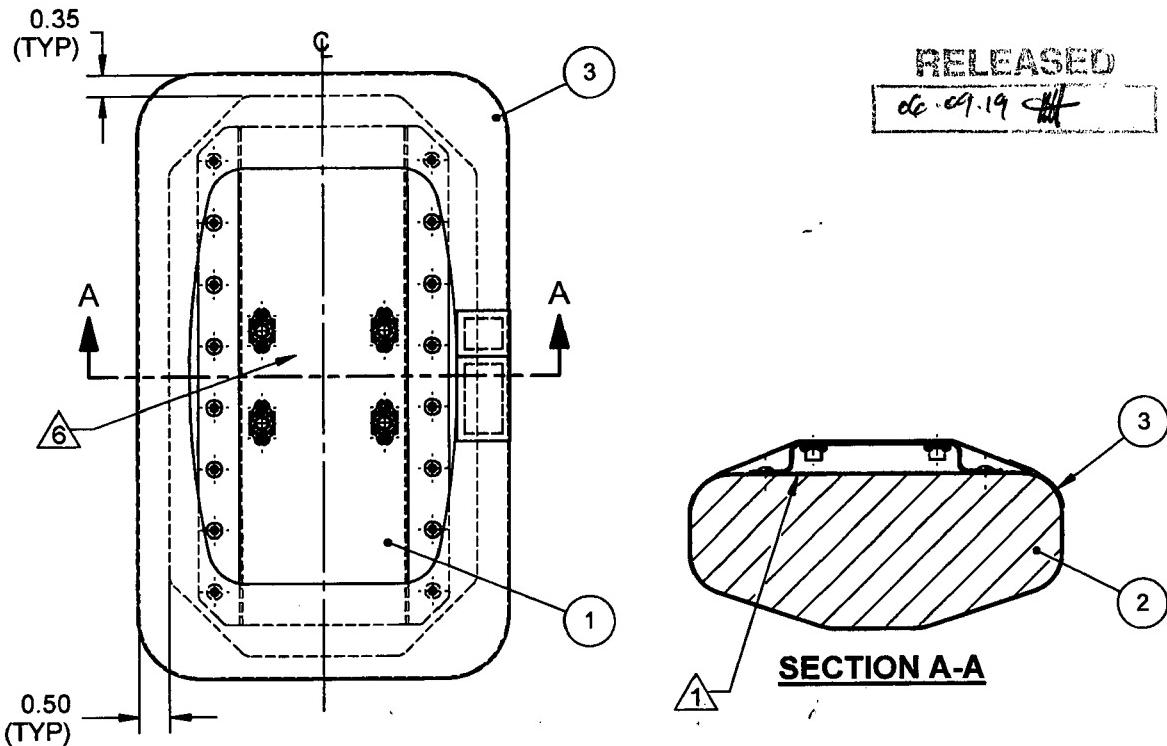
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>RF</i>	DRAWN BY <i>JS</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 1 OF 4
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>	SCALE 1:3	

REV	DATE	DESCRIPTION
A	04.08.18	NEW ISSUE
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

SHOP COPY  
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ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *41650*

**NOTES:**

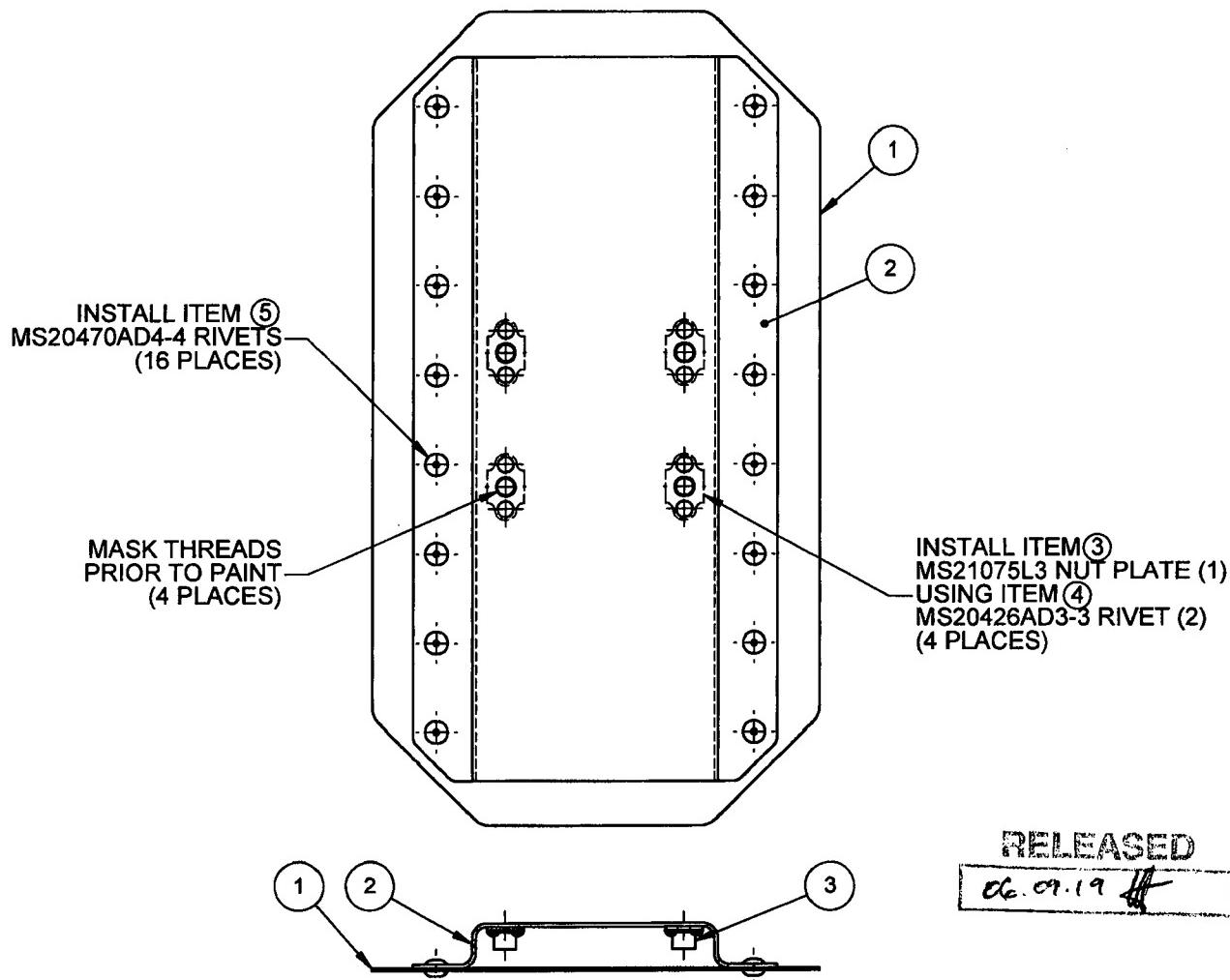
- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT  
ELIGIBILITY SEE PDA04-11"

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**DART**

DESIGN <i>PF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. <b>D3303</b>	REV. B SHEET 2 OF 4
DATE <b>06.08.17</b>	TITLE <b>HEAD REST</b>	SCALE 1:2	

**D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

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WORK ORDER  
*NO. 41650*

**NOTES:**

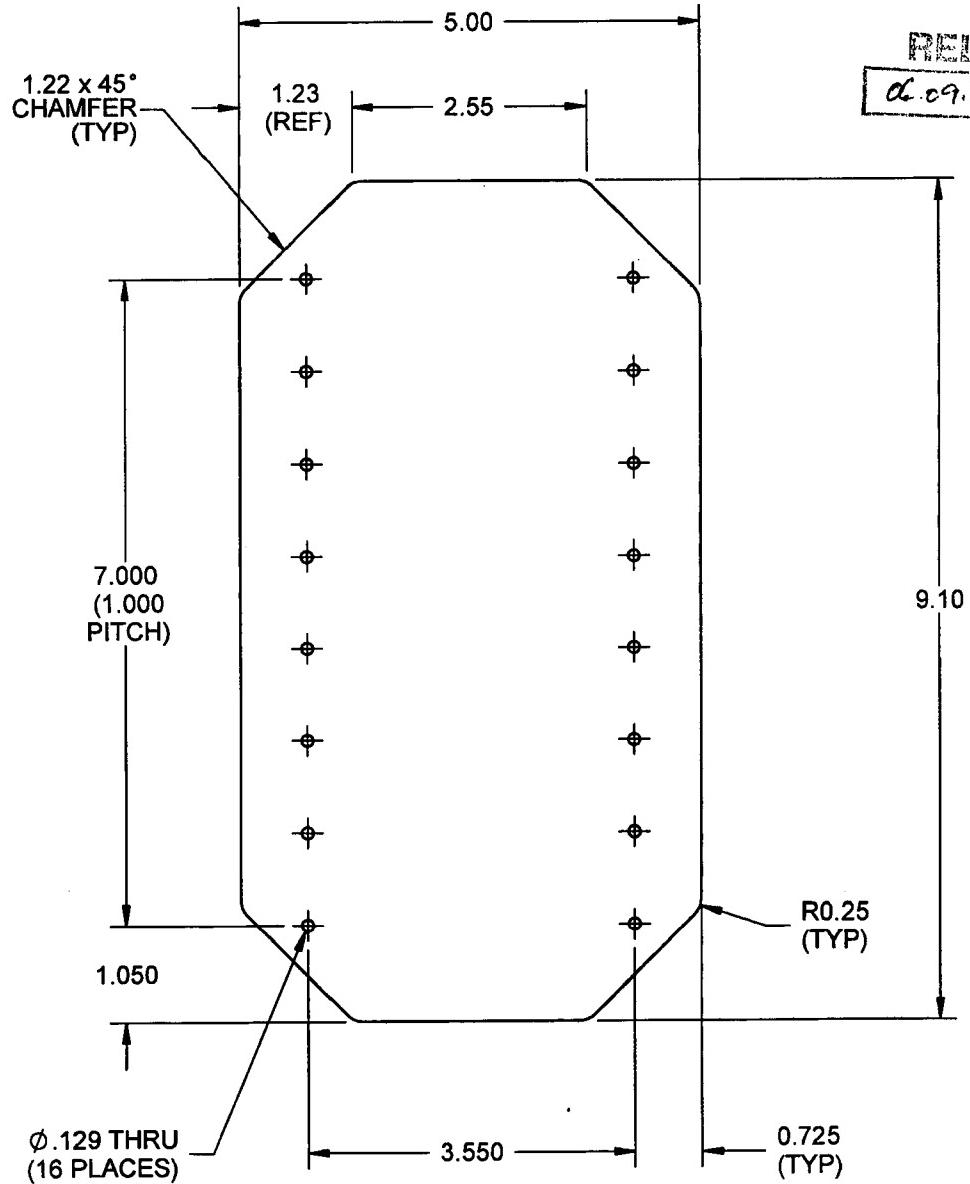
- 1) FINISH: POWDER COAT ASSEMBLY GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3303	REV. B	SHEET 3 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2		

**D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET  
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

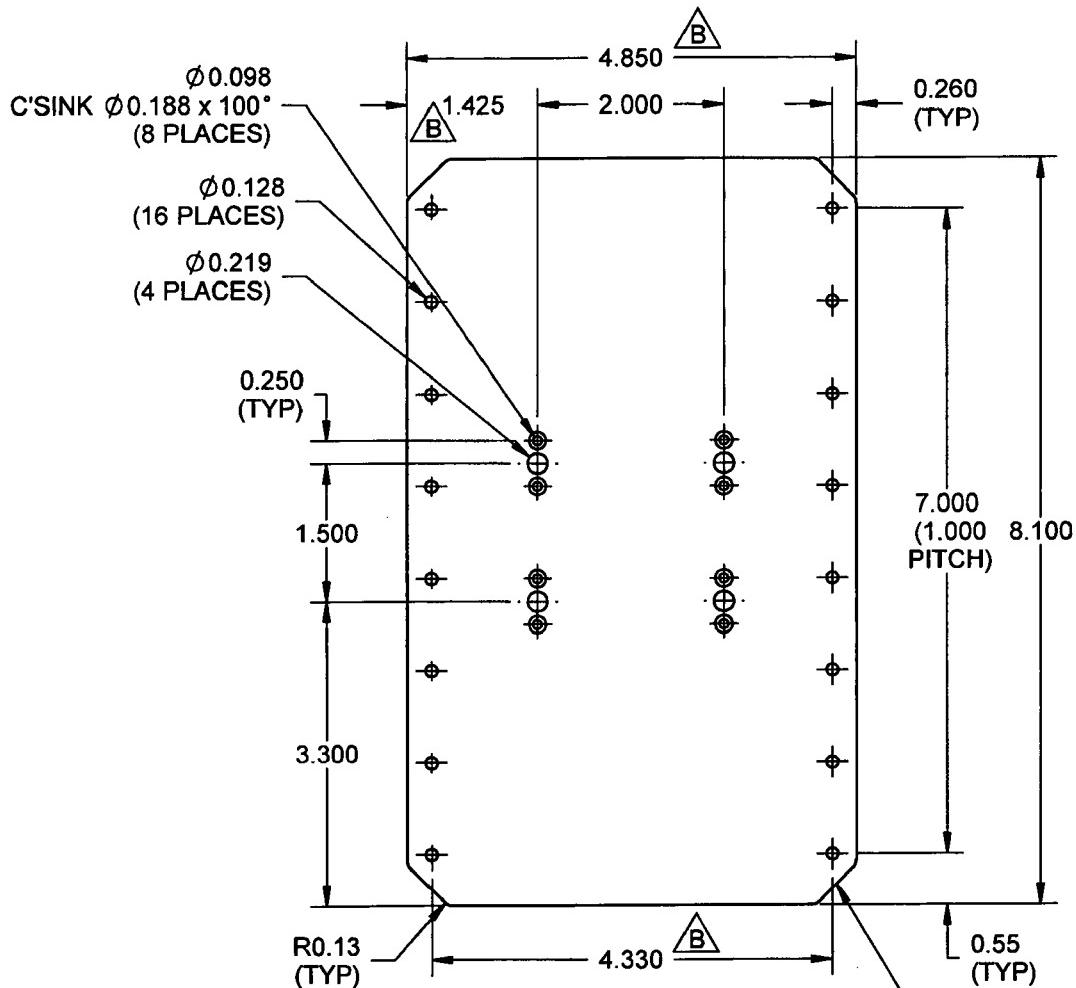
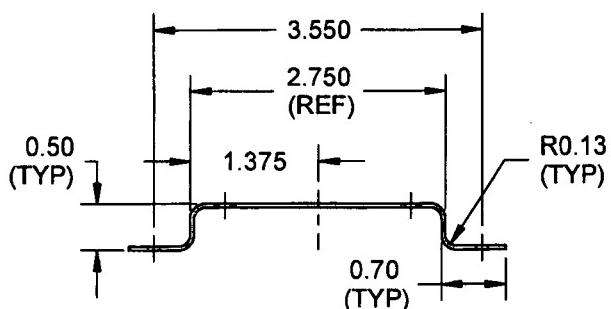
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**DART**

DESIGN <i>RF</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>JF</i>	DRAWING NO. D3303	REV. B	SHEET 4 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2		

**△ B D3303-3F BRACKET FLAT PATTERN****D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET  
(REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER  
DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE  
NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

NO. *4650*